

Split Work Order ID 80671-2

February-24-12 3:30:51 PM

80671

Page 1

Item ID: D4434-043

Revision ID:

Accept

N9000040100

Setup Start *NS1*

Item Name: Fwd inboard Bracket Assembly 3

Start Date: 24/02/2012 Start Qty: ~~10.00~~

Stop *NS2*

Required Date: 15/03/2012 Req'd Qty: 10.00

10

Cust Item ID:

10

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12/02/23 Tooling:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4434

L B 6LN 12-537 W

100

0.00

100

Waterjet

FLOW WATER JET

FLOW CNC Waterjet

Memo

0.00

1-Cut D4434-1 as per Dwg

Dwg Rev: 3

Prog Rev: 3

2-Deburr if necessary

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

M 12 03 15 (10)

M 12 03 15 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4434-043

Revision ID:

Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012 Start Qty: 10.00

Required Date: 15/03/2012 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

07/03/16

410

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Brake NC

Memo

0.00

07/03/19

07/03/19

10
19

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

12-03-19 (B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4434-043

Revision ID:

Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012 Start Qty: 10.00

Required Date: 15/03/2012 Req'd Qty: 10.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

160

160

HandFinish

Hand Finishing

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

② 7/6 - 12/3/19

170

170

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

10X Ø M / 12/03/19

180

180

Small Fab

Small Fab

Memo

Assemble as per dwg. do not install grommets and rubber seal.

0.00

0.00

FF ③ # 12-03-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80671

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Item ID: D4434-043

Revision ID:

Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012 Start Qty: 10.00

Required Date: 15/03/2012 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

185

185

QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/C

Memo

Set Up/
Run Hours

0.00

0.00

S-265/27

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			(f3)			

190

190

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

S-9h25

0.00

T-320°F

M117 338

F-9h55

3 12/03/28

200

200

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

3 BK 12 3-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D4434-043

Revision ID:

Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012 Start Qty: 10.00

Required Date: 15/03/2012 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

202

202

Small Fab

Small Fab

Memo

Install rubber seals and grommets.

3M 1300 batch: 12120954

0.00

0.00

③ FF 12-03-29

205

205

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SS 12/03/29

③

210

210

Packaging

Packaging

Identify as per dwg & Stock Location: GA

Memo

0.00

0.00

SS 12/03/29

③

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Item ID: D4434-043

Revision ID:

Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012 Start Qty: 10.00

Required Date: 15/03/2012 Req'd Qty: 10.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2******10***

Cust Item ID:

Customer:

10

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

220

QC21- Final Inspection - Work Order Release

0.00


220

QC

Memo

0.00

Quality Control

12/3/29 
MF
12-03-29

Picklist Print

February-24-12 3:30:55 PM

Page 1

Work Order ID: 80671

80671

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD IPP RevB
11.12.22 per PA5 EC verified by:JLM IPP RevC 12.01.24
per REV.A DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

100

sf

294.9670

2.5

26.31579

**

12.03.15

M6061T6S 040

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

294.967

117653

27.91

120154

90

120218

177.057

D4434-9

Manufactured

No

180

Each

1.0000

1

10

**

③ FF 12-03-29

D4434-9

Bracket

Location

Loc Qty

Loc Code

GA

80675
79508

1

1

1.0000

1

10

**

③ FF 12-03-29

D4435-041

Manufactured

No

180

Each

1.0000

1

10

D4435-041

Bracket Assembly

Location

Loc Qty

Loc Code

ST139B

79371
80678

1

1

3

Picklist Print

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Page 2

Work Order ID: 80671

Parent Item: D4434-043

Parent Item Name: Fwd Inboard Bracket Assembly

80671

D4434-043

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

D4441-1

Manufactured No

202

f

24.7270

0.142

1.42

**

③ FF 12-03-29

D4441-1

Rubber Seal

B79385

0.426

Location

Loc Qty

Loc Code

prelim

24.727

74760

24.727

Cut qty 1 to 1.7"

D4441-1

Manufactured No

f

24.7270

2.08

**

③ FF 12-03-29

D4441-1

Rubber Seal

79385

0.624

Location

Loc Qty

Loc Code

prelim

24.727

74760

24.727

Cut qty 1 to 2.5"

D4441-1

Manufactured No

f

24.7270

18.75

**

③ FF 12-03-29

D4441-1

Rubber Seal

79385

5.625

Location

Loc Qty

Loc Code

prelim

24.727

74760

24.727

Cut qty 1 to 22.5"

D4440-1

Manufactured No

202

Each

20.0000

1

10

**

③ FF 12-03-29

D4440-1

Grommet

Location

Loc Qty

Loc Code

prelim

2

74759

2

PREst

8

77917

8

ST139F

10

79372

10

80645

3

February-24-12 3:30:55 PM

Shop Packet Print

Page 2

February-24-12 3:30:55 PM

Work Order ID: 80671

Parent Item: D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

80671

D4434-043

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN525-832R6

Purchased

No

180

Each

511.0000

3

30

AN525-832R6

**

Screw

③ FF 12-03-29

LocationLoc QtyLoc Code

ST345

511

120308

11

120560

500

9

MS20426AD3-2

Purchased

No

180

Each

18,319.00

12

120

MS20426AD3-2

**

Rivet

③ FF 12-03-29

LocationLoc QtyLoc Code

Mezz

121011

18319

1173

8919

13276

9400

36

MS20426AD3-3

Purchased

No

180

Each

2,749.000

2

20

MS20426AD3-3

**

Rivet

③ FF 12-03-29

LocationLoc QtyLoc Code

ST316

2749

119109

2246

19099

503

6

MS20470AD4-3

Purchased

No

180

Each

5,874.000

5

50

MS20470AD4-3

**

Rivet - Universal Head

③ FF 12-03-29

LocationLoc QtyLoc Code

Mezz

5874

1612

1240

2193

4634

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-24-12 3:30:55 PM

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Work Order ID: 80671

80671

Parent Item: D4434-043

D4434-043

Parent Item Name: Fwd inboard Bracket Assembly

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

MS210751.08

Purchased

No

180

Each

364.0000

7

70

MS210751 08

**

ANCHOR NUT

(3) FF 12-03-29

Location

Loc Qty

Loc Code

ST303

302

111578

2

120560

300

21

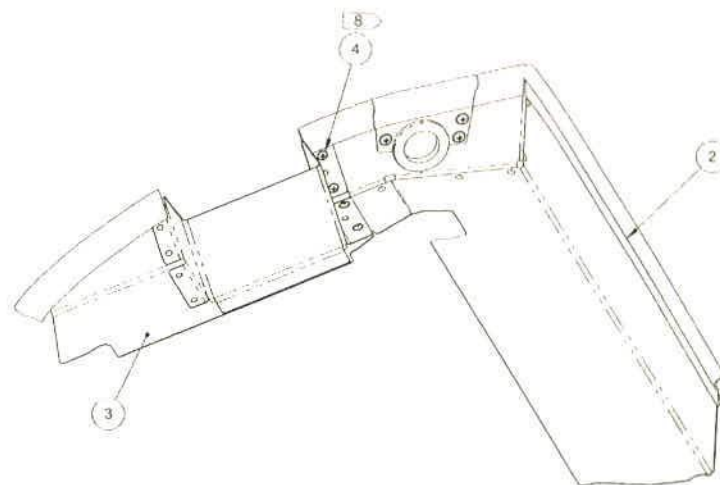
ST304

62

120121

62

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4434-041	FWD BRACKET ASSEMBLY
2	1	D4434-043	FWD INBOARD BRACKET ASSEMBLY
3	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



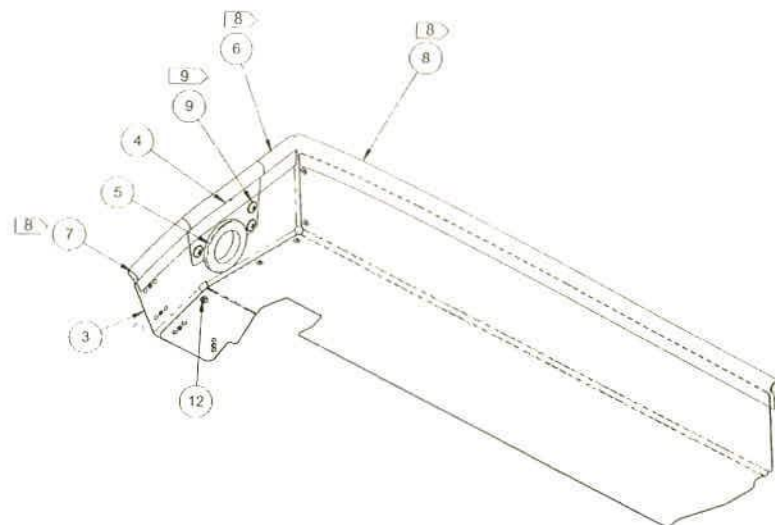
D4434-041 FWD BRACKET ASSEMBLY

NOTES:

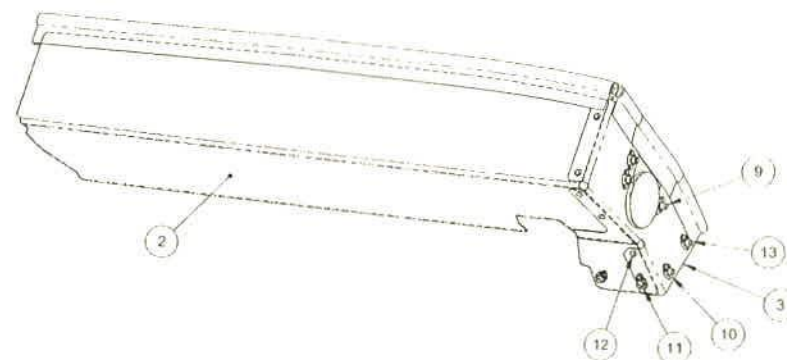
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044.6.1
- 7) WEIGHT: 1.43 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

B	RE-DESIGN D4434-97-9F (ZN BS-14, AS-15)	RF	12.02.22
A	NEW ISSUE	RF	12.01.17
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4434	SHEET 1 OF 15
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	NTS
DATE	12.02.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD	

RELEASED
2012-05-03



ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4434-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-1	BRACKET
3	1	D4434-9	BRACKET
4	1	D4435-041	BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	1	D4441-1-017	RUBBER SEAL
7	1	D4441-1-025	RUBBER SEAL
8	1	D4441-1-225	RUBBER SEAL
9	3	AN525-B32R6	SCREW
10	12	MS20426AD3-2	RIVET
11	2	MS20426AD3-3	RIVET
12	5	MS20470AD4-3	RIVET
13	7	MS21075L08	NUT PLATE
14	A/R	3M 1300/1300L	ADHESIVE



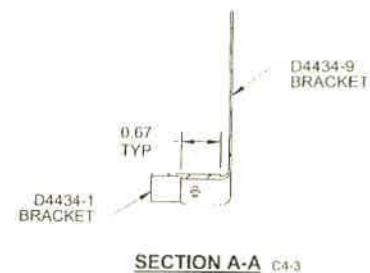
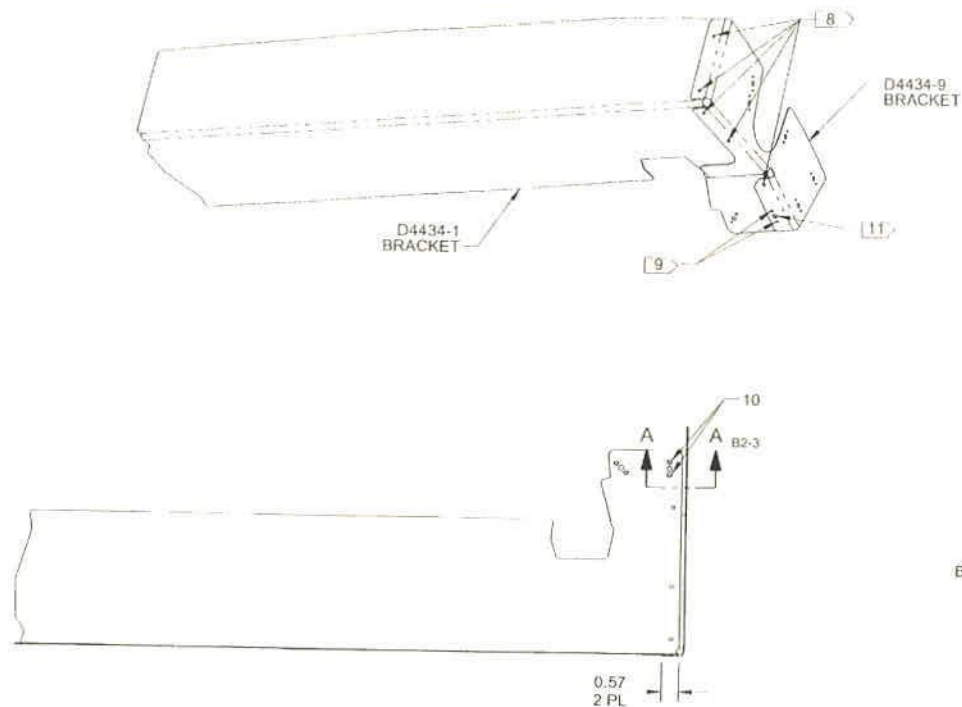
RELEASED
R 2012-05-02

D4434-043 FWD INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005.4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4434	SHEET 2 OF 15
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	NTS
DATE	12.02.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD	



NOTES

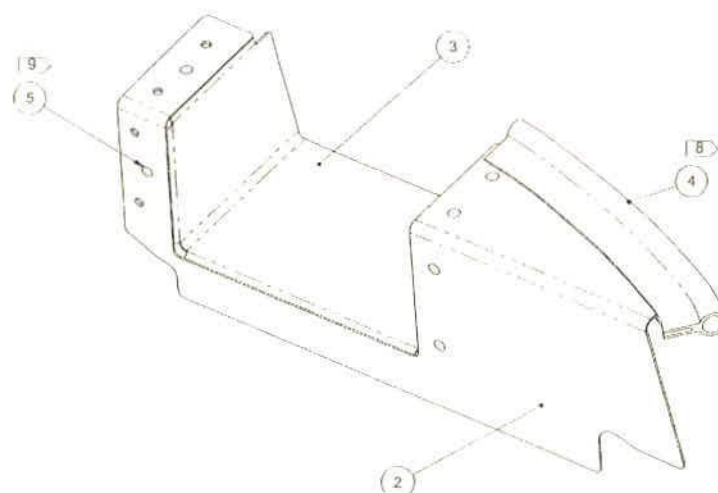
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D4434-1
- 9) TRANSFER $\varnothing 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D4434-1
- 10) CSK $\varnothing 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 11) TRANSFER $\varnothing 0.177$ HOLE THRU FROM D4434-9 TO D4434-1

D4434-043 FWD INBOARD BRACKET ASSEMBLY AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D4434	SHEET 3 OF 15
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>H</i>	COVER ASSEMBLY	NTS
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RELEASED
2012-05-02

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
2	1	D4434-3	BRACKET
3	1	D4434-5	BRACKET
4	1	D4441-1-060	RUBBER SEAL
5	6	MS20426AD4-4	RIVET



D4434-045 FWD OUTBOARD BRACKET ASSEMBLY

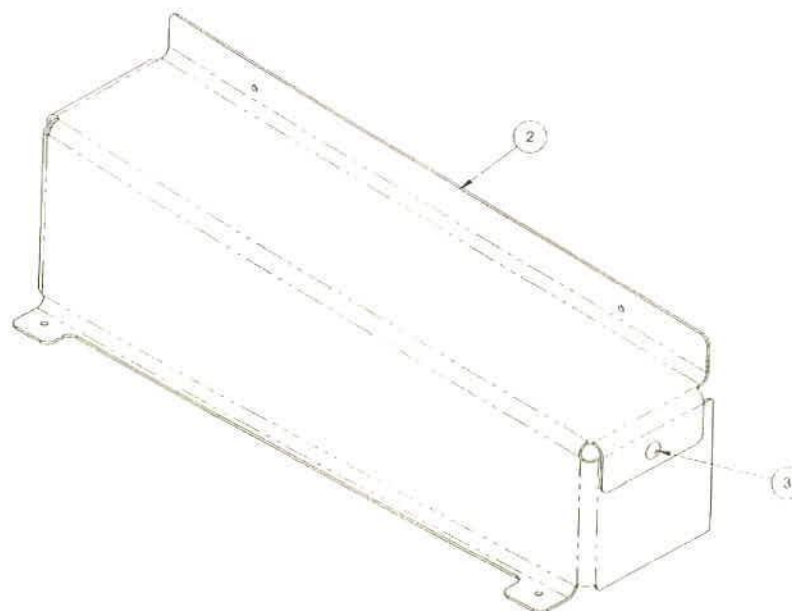
RELEASED
2012-03-02
NA

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.365 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TRANSFER $\phi 0.129$ HOLE 6 PLACES AND CSK TO $\phi 0.225 \times 100^\circ$

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4434	REV. B
MFG. APPR	RF		SHEET 4 OF 15
APPROVED	RF	TITLE COVER ASSEMBLY	SCALE
DE APPR	RF		NTS
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4434-047	COVER ASSEMBLY
2	1	D4434-7	BRACKET
3	2	MS20470AD4-3	RIVET



D4434-047 COVER ASSEMBLY

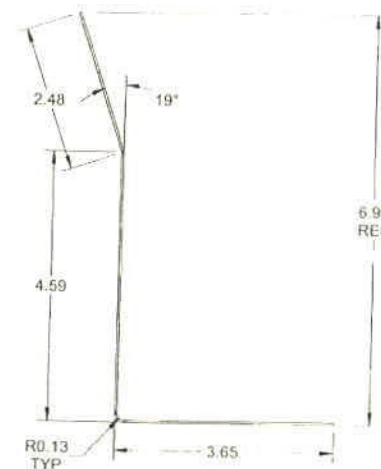
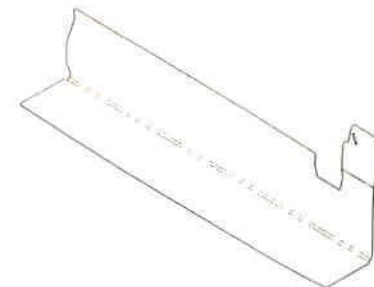
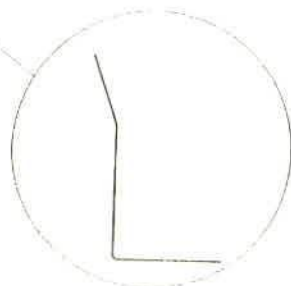
RELEASED
2012-03-02
N/A

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005.4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044.6.1
- 7) WEIGHT: 0.263 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4434	SHEET 5 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
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B
B2-6



D4434-1 BRACKET

DETAIL B C8-6
SCALE 2X

NOTES

- 1) MATERIAL: MAKE FROM D4434-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

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MFG. APPR.	<i>RF</i>	D4434	SHEET 6 OF 15
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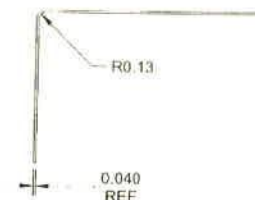
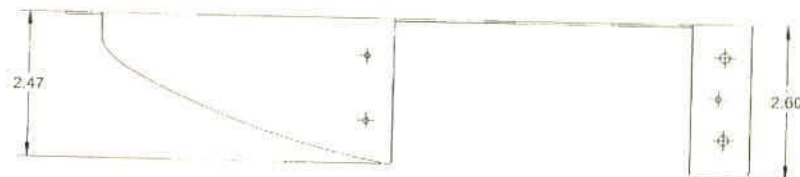
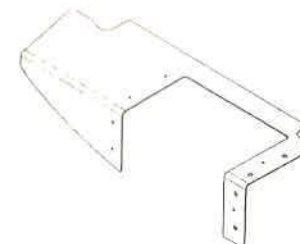
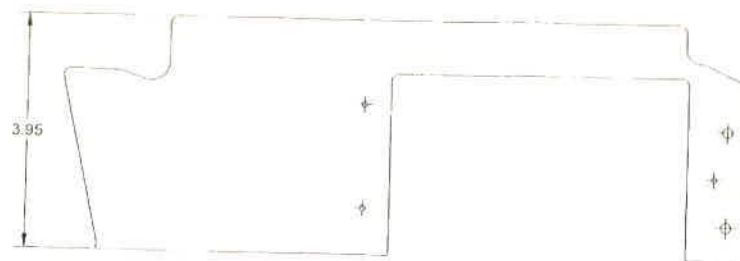


RELEASE
2012-03-02
MM

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M8061T6S.040

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.70 lbs

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DRAWN	RF		SHEET 7 OF 15
CHECKED	<i>RF</i>		
MFG APPR	<i>RF</i>		SCALE
APPROVED	<i>RF</i>		NTS
DE APPR	<i>RF</i>		
DATE	12.02.22		



D4434-3 BRACKET

RELEASE
2012-03-02

NOTES

- 1) MATERIAL: MAKE FROM D4434-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

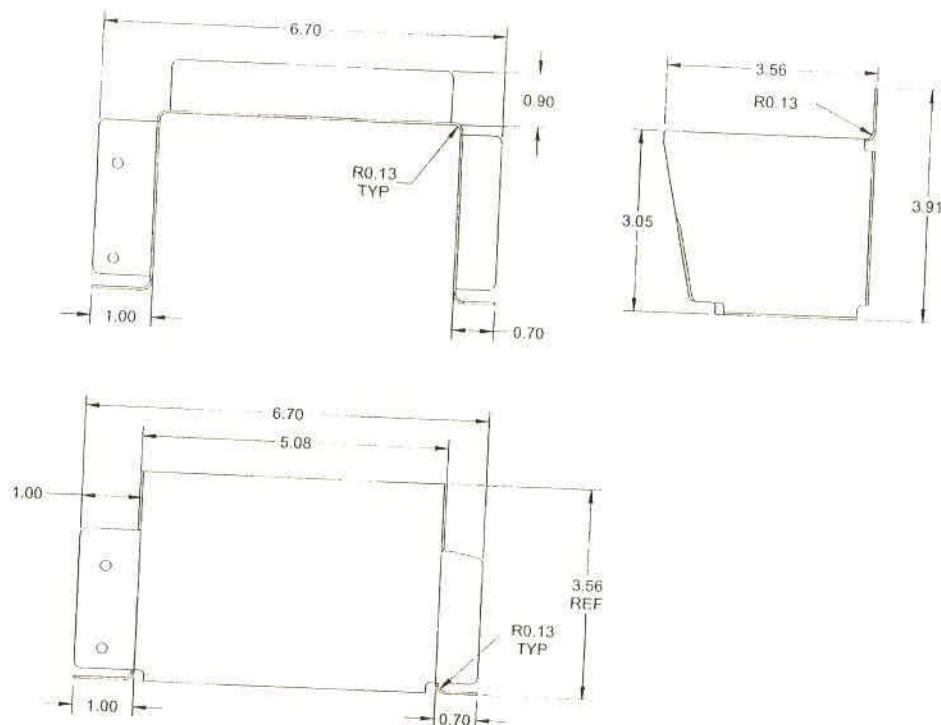
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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4434	SHEET 8 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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NOTES

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.14 lbs

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DRAWN	RF		SHEET 9 OF 15
CHECKED	<i>RF</i>		SCALE
MFG. APPR.	<i>RF</i>		NTS
APPROVED	<i>RF</i>		
DE APPR.	<i>RF</i>		
DATE 12.02.22			



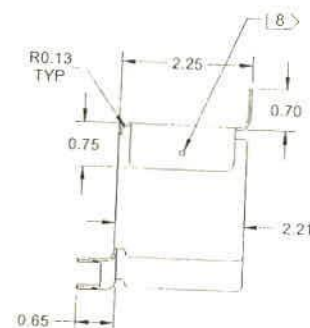
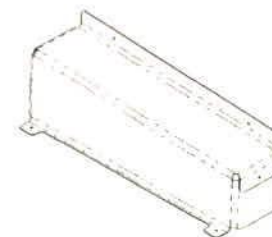
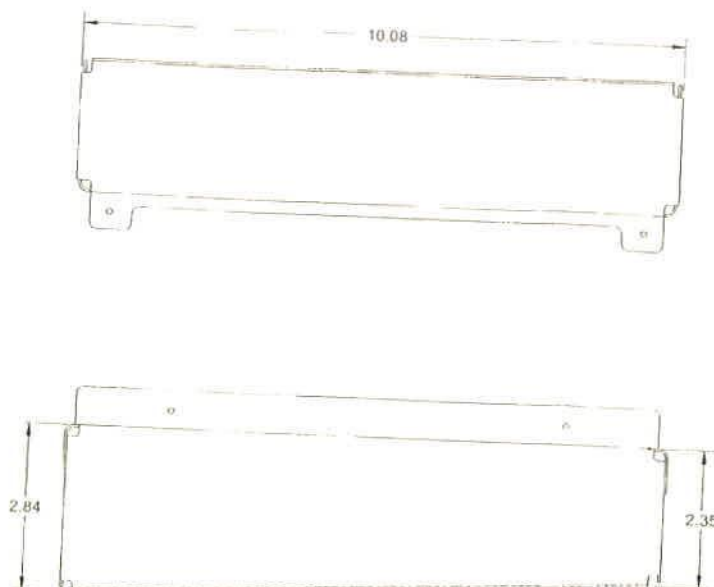
D4434-5 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4434-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

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MFG. APPR.	<i>RF</i>	D4434	SHEET 10 OF 15
APPROVED	<i>RF</i>	TITLE	SCALE
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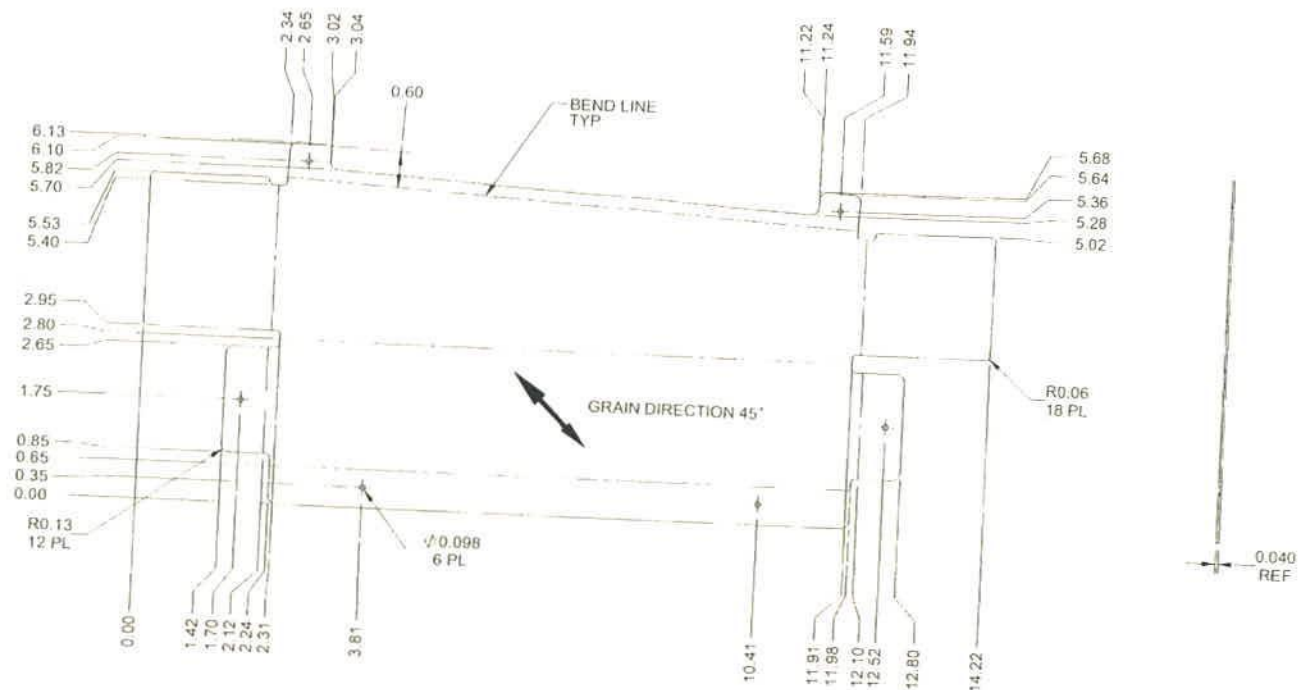
D4434-7 BRACKET

2012-03-02

NOTES:

- 1) MATERIAL: MAKE FROM D4434-7F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs
- 8) TRANSFER $\phi 0.129$ HOLE THRU 2 PLACES

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	141	DRAWING NO.	REV. B
MFG. APPR.	ES	D4434	SHEET 12 OF 15
APPROVED	141	TITLE	SCALE
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D4434-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4434	REV. B
MFG. APPR.	<i>RF</i>	TITLE	SHEET 13 OF 15
APPROVED	<i>RF</i>	COVER ASSEMBLY	SCALE
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JAN



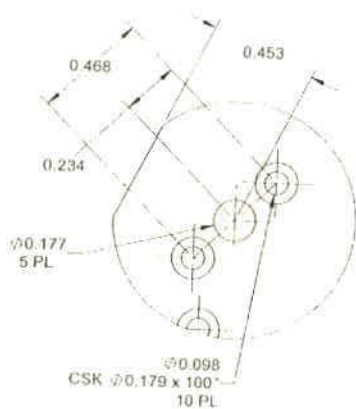
B D4434-9 BRACKET

NOTES

- 1) MATERIAL: MAKE FROM D4434-9F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4434	REV. B
MFG. APPR.	<i>EE</i>	SHEET 14 OF 15	
APPROVED	<i>RF</i>	TITLE	SCALE
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2012-03-03
NW



**DETAIL D
SCALE 2X**

C3-15

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



D4434-9F FLAT PATTERN

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO	REV. B
MFG APPR	RF	D4434	SHEET 15 OF 15
APPROVED	RF	TITLE	SCALE
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WP